

Work Order ID 86436

June-28-12 1:03:38 PM

86436

Page 1

Item ID: D2656-13

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 28/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/06/28* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2656	Rev D					<i>(6)</i>			
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2656 Dwg Rev: <i>D</i> Prog Rev: <i>D</i> 2-								
1010 1040	Deburr if necessary								<i>B12-7-6</i>
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									<i>B12-7-6</i>
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control						<i>(6)</i>			

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Brake NC

NC BRAKE

0.00

0.00

Memo

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT83262-Form
joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

6

12/07/13

140

140

QC

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

12/07/13

16

Quality Control

150

150

Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

0.00

Memo

START TIME: 8:30 OVEN TEMPERATURE:

FINISH TIME: 9:00

320012

9:00

6x

mf

12/07/16

12/279

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Stop

NS2

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Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

6x 4 12/11/07/16

170

Identify as per dwg & Stock Location

0.00

170

Packaging

Memo

0.00

Packaging

FP7
Store

6X 0 12/07/16

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/7/18

MCJ 12/07/16

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NOTE: Date & initial all entries

Picklist Print

June-28-12 1:03:42 PM

Page 1

Work Order ID: 86436

86436

Parent Item: D2656-13

D2656-13

Parent Item Name: Wearplate

Start Date: 28/06/2012

Required Date: 12/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: F 02.10.25Re-formatKJ/RF
IPP Rev:G Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S20GA		Purchased	No			100	sf	190.3700	0.85	5.1			

M1010S20GA

**

B2-7-6

1010/1025 SHEET

Location

Loc Qty

Loc Code

MAT019

190.37

111410

26.9

116791

41.17

121780

122.3

121780

6

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Dart Aerospace Ltd

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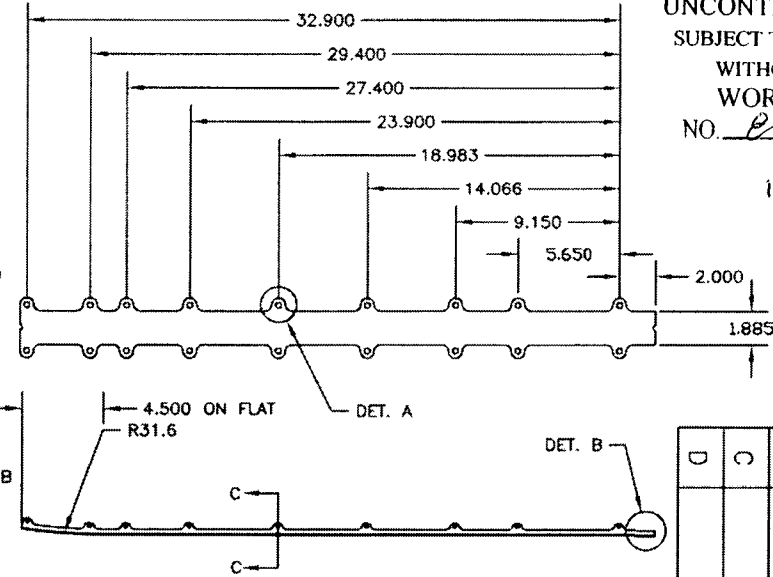
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 204364W

12/06/28

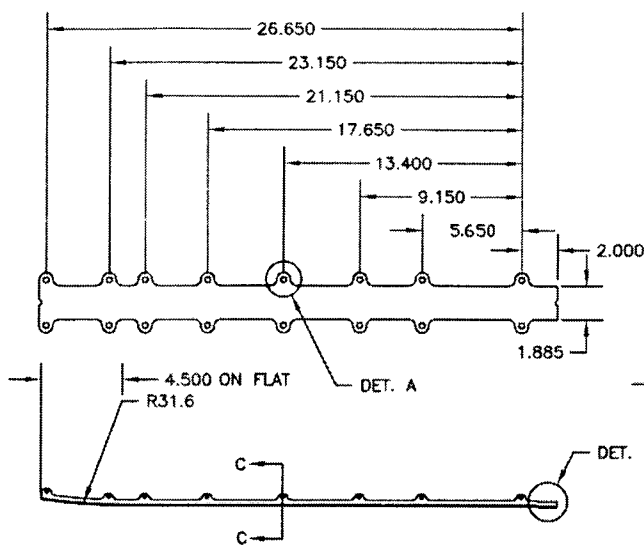


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DS	CP	D2656		
CHECKED	APPROVED	DRAWING NO.		SHEET 1 OF 4
DATE		TITLE		SCALE
05.08.17		WEARSHOE		1:10
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

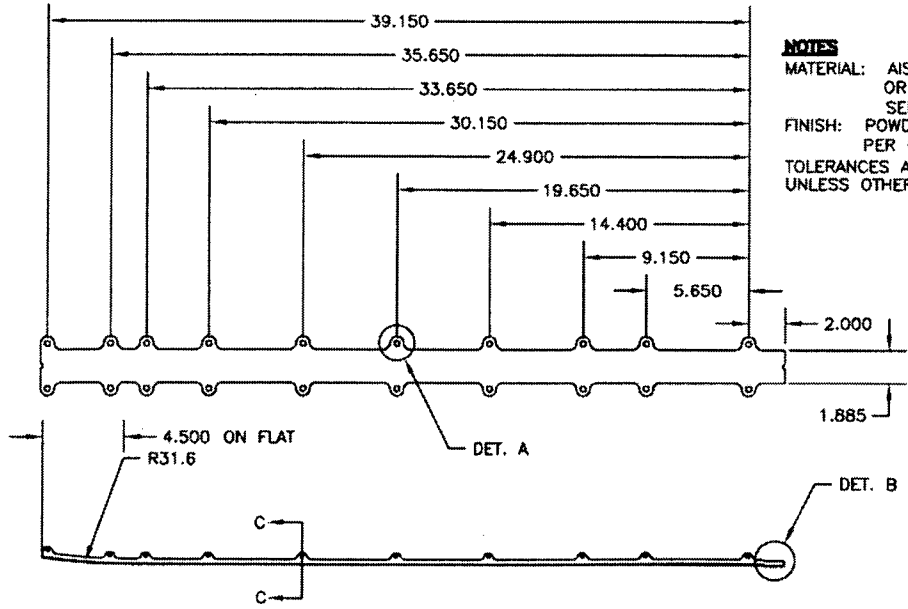
D2656-13



D2656-11



D2656-15



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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05-09-02

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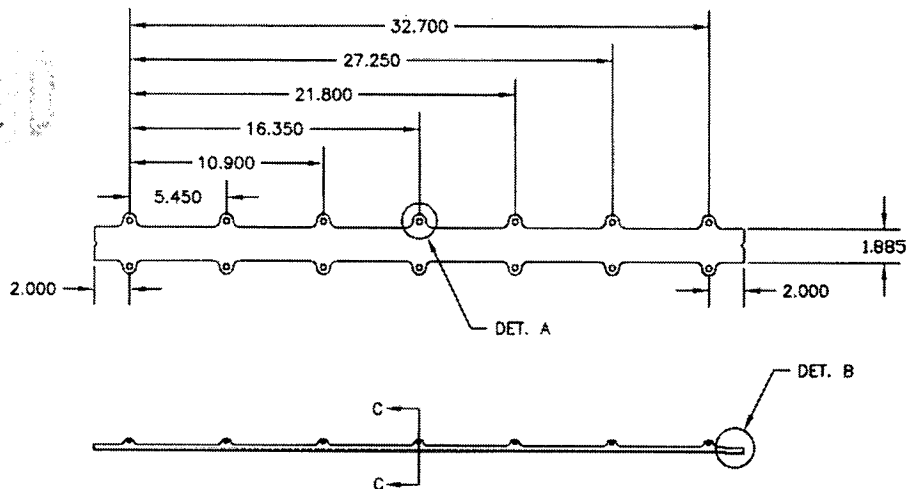
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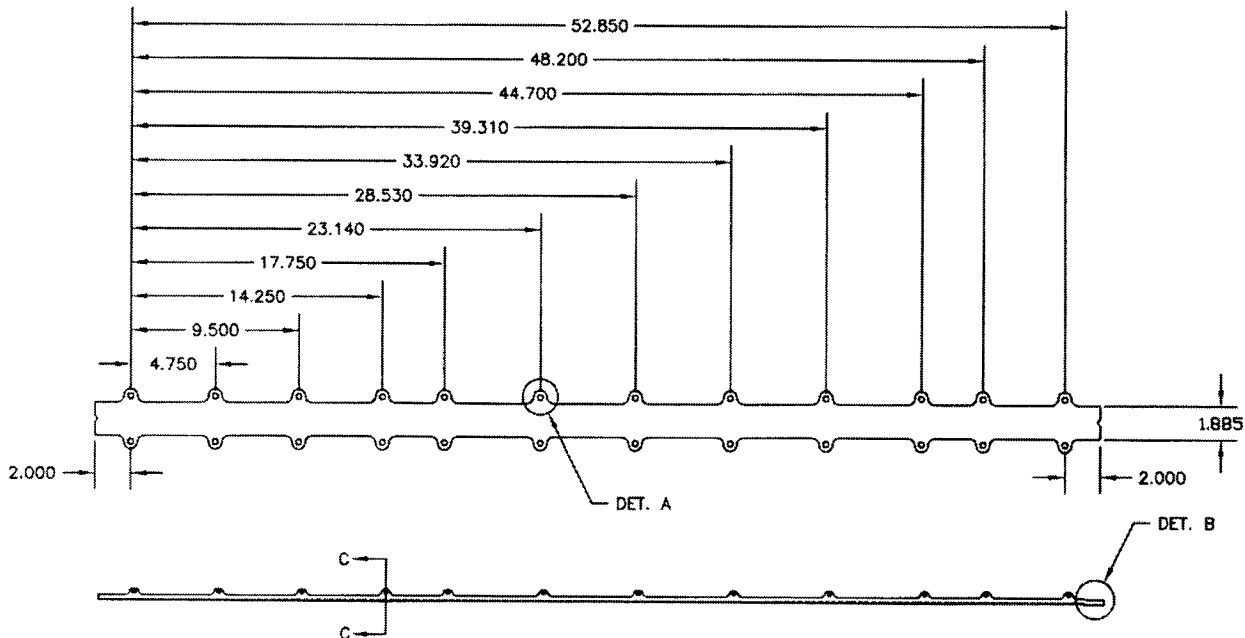


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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
 SERIES STEEL, 20 GAUGE (0.040 THICK)
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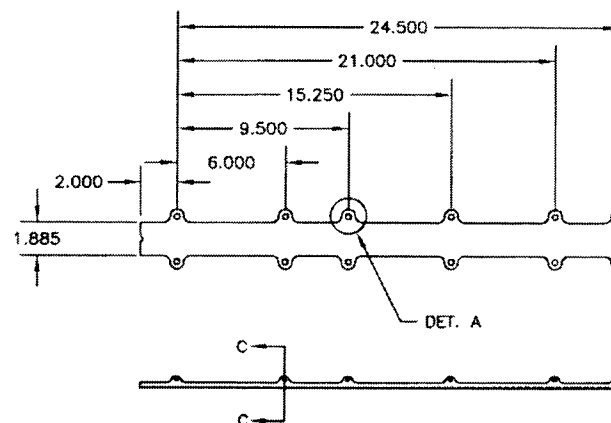
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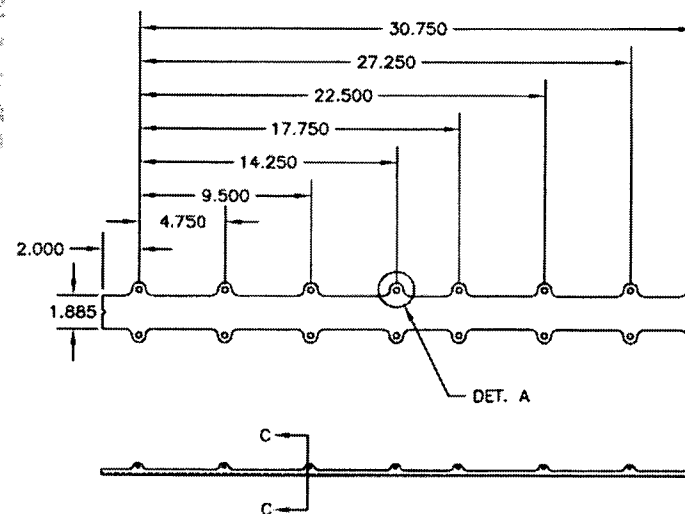


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		SCALE	1:10	
		SHEET 3 OF 4		
		REV. D		

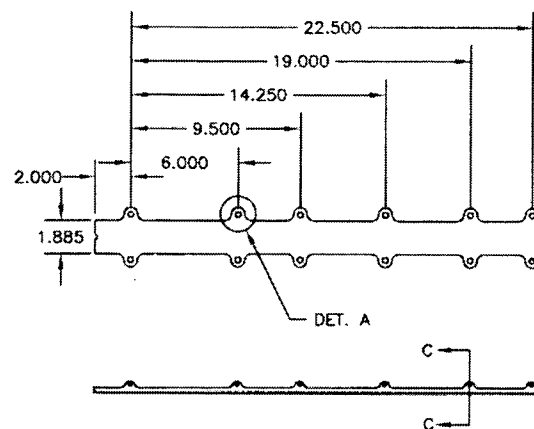
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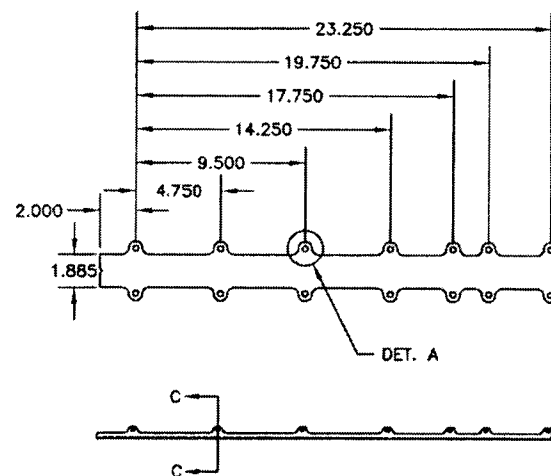
D2656-37



D2656-31



D2656-35



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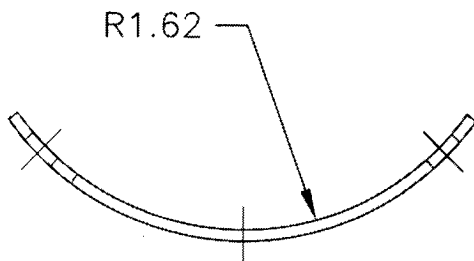
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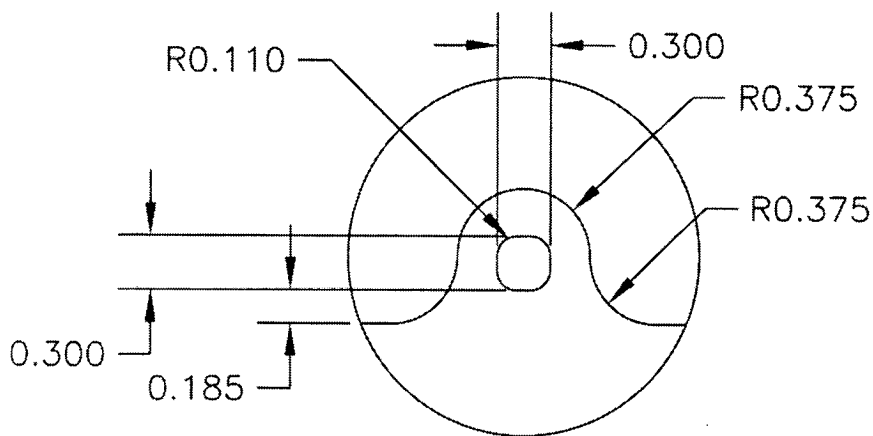
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
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DATE	05.08.17			TITLE	SCALE
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SECTION C-C

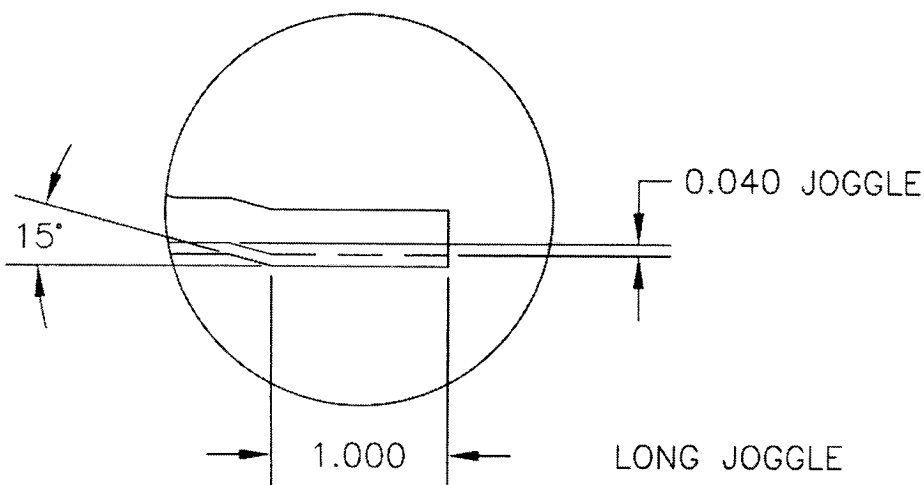


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DETAIL A



DETAIL B



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